

303, 150

Work Order ID 68939

Tuesday, April 26, 2011 10:22:00 AM



Page 1

Item ID: D3501-1

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 4/27/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/26/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-04-27 Tooling:

Date:

Run Start

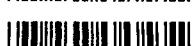


QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

D3501	Rev A								
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100 Hardinge CNC LATHE SMALL
 Hardinge
 Hardinge CNC Lathe Small
 Memo I-TURN AS PER FOLIO FA650 & DWG D3501, FOLIO
 REV: A DWG REV: A DEBURR AS REQUIRED

SL 11/6/9

110 QC2- Inspect parts off machine FAI/FAIB

0.00

102

QC
 Quality Control
 Memo

0.00

102

120 QC8- Inspect parts - second check
 QC
 Quality Control
 Memo

0.00

RP 10.6.9

102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68939

Tuesday, April 26, 2011 10:22:00 AM



Page 2

Item ID: D3501-1

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 4/27/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/26/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



Packaging

Packaging

Identify as per dwg & Stock Location: 063Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

4/26/10 *102*

*MF**11-06-10*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

list Print

Tuesday, April 26, 2011 10:21:57 AM

Page 1

Work Order ID: 68939



Parent Item: D3501-1



Parent Item Name: Bushing

Start Date: 4/27/2011

Required Date: 5/26/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A New Issue 06-05-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750 303 Round Bar 0.750		Purchased		No		100	f	141.0500	0.0791	8.326316		SA 10/6/9	

Location	Loc Qty	Loc Code
MAT028	141.05	
117142	26.05	
117328	55	
117481	60	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

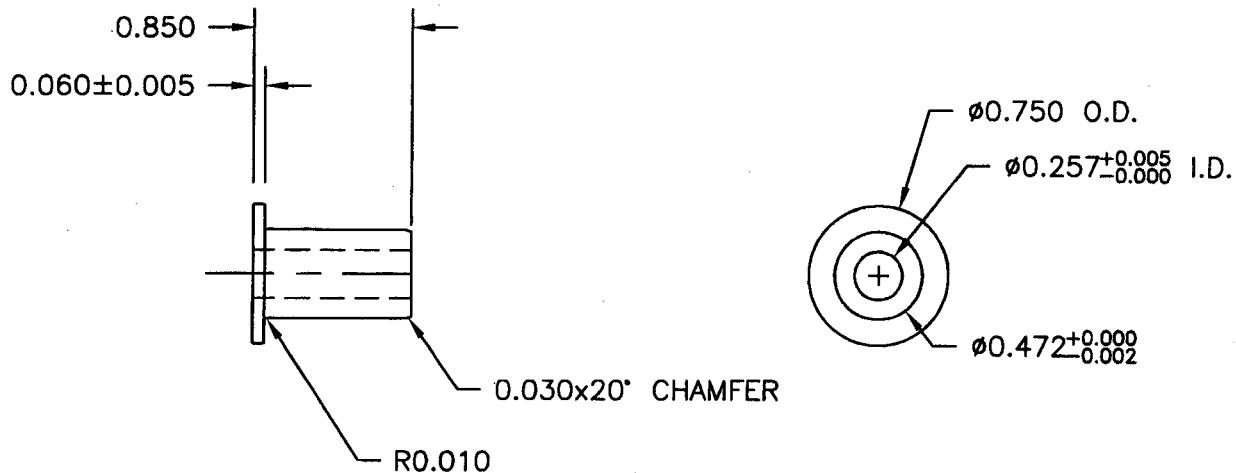
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>gp</i>	DRAWN BY <i>gp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3501	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE BUSHING	SCALE 1:1
A	06.04.18	NEW ISSUE	

**D3501-1 BUSHING**

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED06.08.15 *ff*

DART AEROSPACE LTD	Work Order:	68439
Description: Bushing	Part Number:	D3501-1
Inspection Dwg: D3501	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>PJ</u>	Audited by:	<u>RQ</u>	Prototype Approval:	N/A
Date:	11/6/9	Date:	11.6.9	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	JL